

Date: Monday, 2/27/2006 4:17:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT FRAME ASSEMBLY		
Job Number	: 25960		Part Number	: D3016041		
Estimate Number	: 11122		Drawing Number	: D3016 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/27/2006	S.O. No. : N/A	Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/30/2006		
Previous Run	: 25790		Qty:	1	Um:	Each
Written By	: See Comment Below					
Checked & Approved By	: <u>PSJ 06.02.28 v</u>					
Comment	: Est. A 01.09.19 New issue EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W		
		Comment: Qty.: 6.8250 f(s)/Unit Total : 6.8250 f(s) 4130 Tube .750 OD x.049W Cut- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: M10498		<u>06/07/26 ①</u>
2.0	M4130NT1000W049	4130 Tube 1.0"D X .049"W		
		Comment: Qty.: 2.6250 f(s)/Unit Total : 2.6250 f(s) 4130 Tube 1.0"D X .049"W		<u>06/07/26 ①</u>
3.0	M4130NT0500W049	4130 Tube .500 OD x.049W		
		Comment: Qty.: 4.2000 f(s)/Unit Total : 4.2000 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: M1105		<u>06/07/26 ①</u>
4.0	D301617	Gusset		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset Pick: Qty Part Number Description Batch		
	1	D3016-17	Gusset	<u>B22066</u>
				<u>06/07/26 ①</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SEAT FRAME ASSEMBLY

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Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D301613 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
1	D3016-13	Bracket	B16404

M 06/07/27

6.0 D301615 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
1	D3016-15	Gusset	B25762

M 06/07/27

7.0 D30201 Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
2	D3020-1	Fitting	B22690

M 06/07/27

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

06/07/28

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Weld as per Dwg D3016

A/R Steel Rod Batch: M9430

4-Transfer Drill Holes to D3016-041 From D3021-041

M 06/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/08/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 25960

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

Weld as per Dwg D3016 using Welding Jig DT8597

PD 06-07-28

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

SC 06/07/31 ①  
DV

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/08 ①

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/03/08 ①

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/08/15

Job Completion



① 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**O/A COPY  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3016	SHEET 1 OF 3
DATE		TITLE	SCALE
01.05.18		SEAT FRAME ASSEMBLY	NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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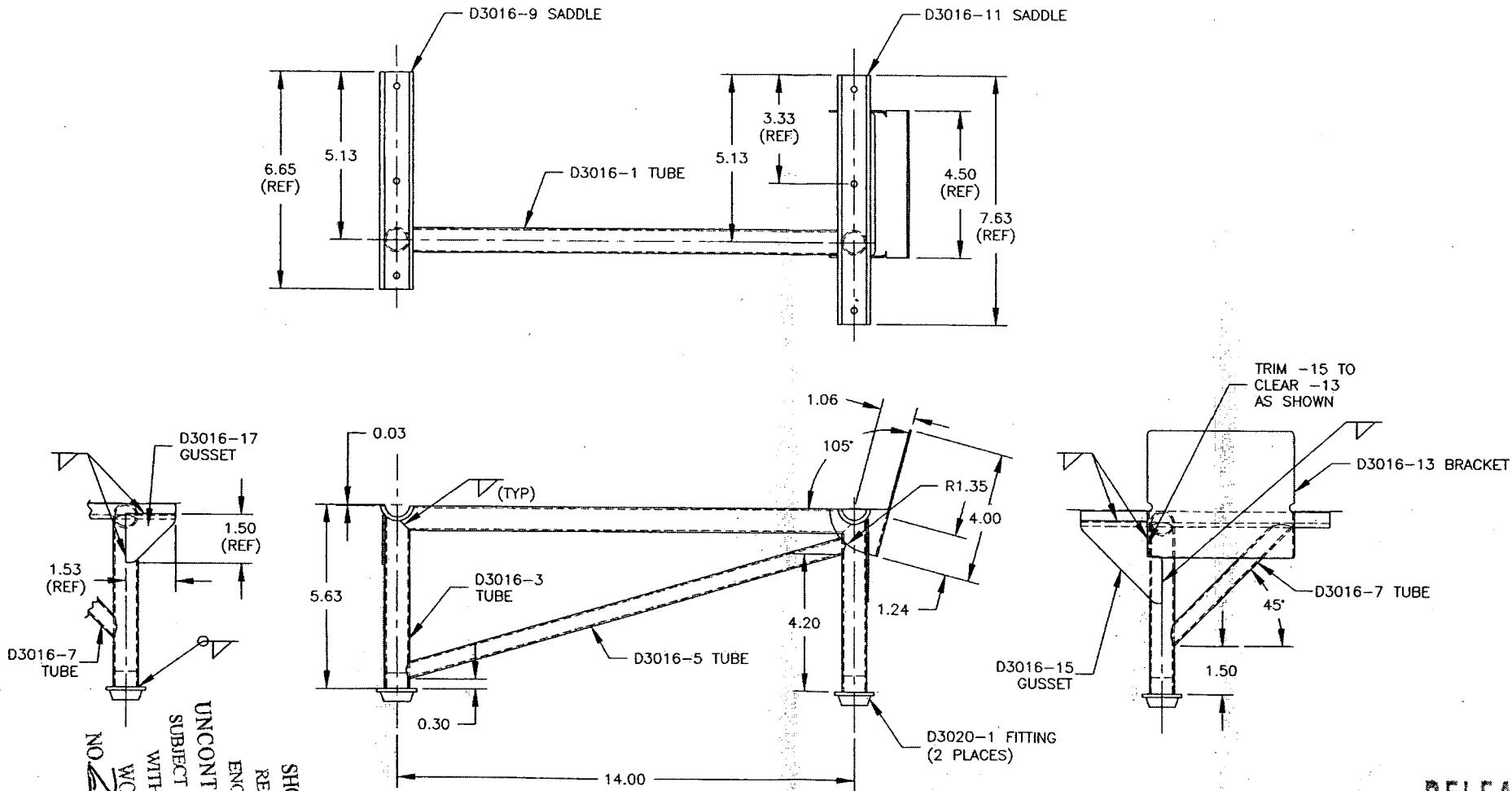
WORK ORDER

NO. 25960RELEASE  
01.05.30

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D3016-041 SEAT FRAME ASSEMBLY



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WORK ORDER  
NO 25960

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DESIGN

CP

DRAWN BY

CP



DART AEROSPACE LTD.  
HAWKSBURY, ONTARIO, CANADA

REV. A

DRAWING NO. D3016 SHEET 2 OF 3

DATE 01.05.18

TITLE SEAT FRAME ASSEMBLY

SCALE 1:3

RELEASED  
01-05-30

